



Dart Hawkesbury
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4956-23
Job Sheet 168212



Part No: D4956-23

Job Qty: 15 ea

Part Name: Wearplate Center Fwd



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 11/13/17

Job Tracking No:

Due Date: 11/22/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG REV A SHEETS 4,8 IPP REV:A 14.04.22 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup	Run	Workcenter / Supplier	Lead Time	
					hrs	Hrs			
90	Start up Operation	15 Ea		11/21/17	0.00	0.00	Start Up Waterjet1		De 17/12/22
100	Waterjet	15 pcs		11/21/17	0.00	4.16	Waterjet1		De 17/12/22
120	QC	15 pcs		11/21/17	0.00	0.00	QC8		38
130	Brake NC	15 pcs		11/21/17	0.15	0.67	Brake NC 1		38
140	QC	15 pcs		11/21/17	0.00	0.00	QC5		38
150	HandFinish	15 pcs		11/22/17	0.00	1.45	HandFinish4		AB JAN 09 2019
160	QC	15 pcs		11/22/17	0.00	0.00	QC3		PD 1
170	Packaging	15 pcs		11/22/17	0.00	0.00	Packaging3		14/01/18
180	QC21-SA	15 Ea		11/22/17	0.00	0.00	QC21		209

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M304S20GA	19	131	0	0

508263

19.6

Rockwood 138205

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	0.188Inches + 0.005 - 0.001	0.193 0.187	Diameter	
2	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
3	Wearshoe	0.300Inches ± 0.010	0.310 0.290		
4	Wearshoe	1.885Inches ± 0.010	1.895 1.875		
5	Wearshoe	2.000Inches ± 0.010	2.010 1.990		
6	Wearshoe	6.750Inches ± 0.010	6.760 6.740		
7	Wearshoe	11.500Inches ± 0.010	11.510 11.490		
8	Wearshoe	16.750Inches ± 0.010	16.760 16.740		
9	Wearshoe	25.140Inches ± 0.010	25.150 25.130		

PART NO:
Revision:
Operation:
Change No:

D4956-23

Start up Operation

Mfg Date: 12/22/17
Job No: 168212

DART
AEROSPACE
S026889



Wearplate Center Fwd

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

10	Wearshoe	30.530inches ± 0.010	30.540	30.520
11	Wearshoe	35.920inches ± 0.010	35.930	35.910
12	Wearshoe	41.310inches ± 0.010	41.320	41.300
13	Wearshoe	46.700inches ± 0.010	46.710	46.690
14	Wearshoe	50.200inches ± 0.010	50.210	50.190
15	Wearshoe	54.850inches ± 0.010	54.860	54.840
16	Wearshoe	56.850inches ± 0.030	56.880	56.820
17	Wearshoe	6.000inches ± 0.030	6.030	5.970
18	Wearshoe	14.000inches ± 0.030	14.030	13.970
19	Wearshoe	22.000inches ± 0.030	22.030	21.970
20	Wearshoe	30.000inches ± 0.030	30.030	29.970
21	Wearshoe	38.000inches ± 0.030	38.030	37.970
22	Wearshoe	45.000inches ± 0.030	45.030	44.970
23	Wearshoe	54.000inches ± 0.030	54.030	53.970

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DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>168212</u> Part No. <u>DY916-23</u> NCR No. _____		DISPOSITION Rework ☒ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☒</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☒	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																																									
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Date : <u>18/1/20</u>		Step #: <u>150</u>		QTY Effective : _____		MRB (QSI042) Approval																																																																																									
Description Work Order Deviation QSI 005 requires use of Axeltz adhesion promoter. Eng test by CP showed no benefit to Axeltz use. Axeltz adhesion promoter is time consuming				Disposition Acceptable to not use Axeltz adhesion promoter. Done AS JAN 09 2018				DAS 12 9-89 18/1/10 Completed By DAS 12 9-89 18/1/10 Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																																																																																							
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Inventory

Operation Number	Operation	Serial Number	Job	Quantity	Weight	Original Serial Number	Location	Container	Status	Added	Special Comments	Label	Supplier	Change No
Part Number: D4956-23 Revision: Wearplate Center Fwd														
180	QC21-SA	S026889	168212	16 Ea	0	S026889	FP001	Bin	Stock	12/22/2017	Issue Container			
Operation Totals:		1		16	0									
Part Totals:		1		16	0									
Part Number: M304S20GA Revision: 304/316 .040 Sheet														
100	Receive sf	S026888	168212	11 sf	0		Start Up Waterjet		Stock	12/22/2017	Issue Container			
Operation Totals:		1		11	0									
Part Totals:		1		11	0									
Totals:		2		27	0									

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